

Wednesday, 14/01/2009 2:27:22 PM
User: melanie Fauteux

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ESCUTCHEON
Job Number	: 44761		
Estimate Number	: 13258		
P.O. Number	:	Part Number	: D37041
This Issue	: 14/01/2009 S.O. No. :	Drawing Number	: D3704 PREL
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: PREL
Previous Run	: 38261	Material	:
Written By	: <i>[Signature]</i> 09-01-14	Due Date	: 16/01/2009 Qty: 5 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 08-04-01 JLM Verified By:DD		

Additional Product

Job Number:



PRELIMINARY ISSUE

Ord. H for escutcheon

Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B0750X01500	6061-T6 Bar .750 X 1.50
	Comment: Qty.: 0.2625 f(s)/Unit Total : 1.3125 f(s) 6061-T6 Bar .75" X 1.5" Batch: <i>M110167</i>	
		<i>K.A 09/01/14</i>
2.0	BAND SAW	BAND SAW
	Comment: BAND SAW Cut blank 3.00 " long	
		<i>K.A 09/01/14</i>
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
	Comment: HAAS CNC VERTICAL MACHINING #1 1- Mill as per Folio FA730 Rev: <i>AA</i> & Dwg D3704 Rev: <i>A</i> 2-Deburr per dwg D3704	
		<i>J.F. 09/01/15</i>
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE	
		<i>J.F. 09/01/15</i>
5.0	QC8	SECOND CHECK
	Comment: SECOND CHECK ENGINEERING APPROVAL	
		<i>09.01.15</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ESCUTCHEON

Job Number: 44761

Part Number: D37041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

G.m 09.01.16 (5)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FX 09/01/16 (5)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *FP*

G.m 09.01.16 (5)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/08

Job Completion



MF 09-01-16

POSITIVE RECALL

EFFECTIVE *09.06.16* AUTH *u*

RELEASED *09.06.05* DATE *1*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 44761
Description: Escutcheon	Part Number: 03704-1
Inspection Dwg: 03704 Rev: A	Page 1 of 1

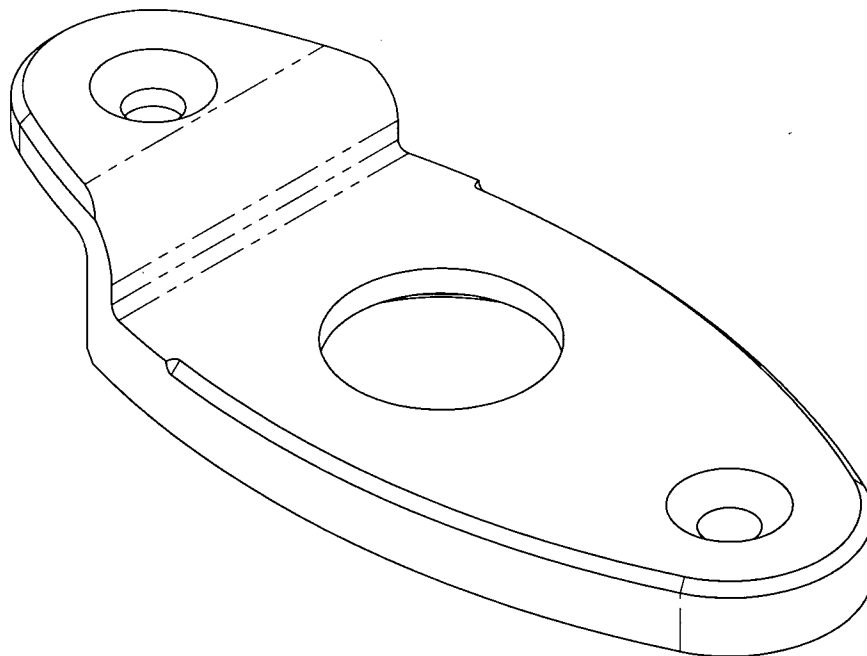
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.125"	$\pm .010$	2.125"				
1.063"	$\pm .010$	1.063"	✓			
Ø.170"	$\pm .005$ $-.001$	Ø.170"	✓			
Ø.322"	$\pm .010$	Ø.332"	✓			
.610"	$\pm .010$					
1.22"	$\pm .030$	1.207"	✓			
.125"	$\pm .010$.135"	✓			
.125"	$\pm .010$.124"	✓			
.500"	$\pm .010$.499"	✓			
R.060"	$\pm .030$	R.060"	✓			
R.19"	$\pm .030$	R.190"	✓			
.625"	$\pm .010$.619"	✓			
.080"	$\pm .005$.076"	✓			
.030" x 45°	$\pm .030$.030"	✓			
.218"	$\pm .010$.215"	✓			
Ø.640"	$\pm .005$ $-.001$.639"	✓			
Ø.935"	$\pm .005$ $-.001$					
2.88"	$\pm .030$	2.860"	✓			

Measured by: J.F.	Audited by: [Signature]	Prototype Approval: N/A
Date: 09/01/15	Date: 09.01.15	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D3704-1 ESCUTCHEON

44761

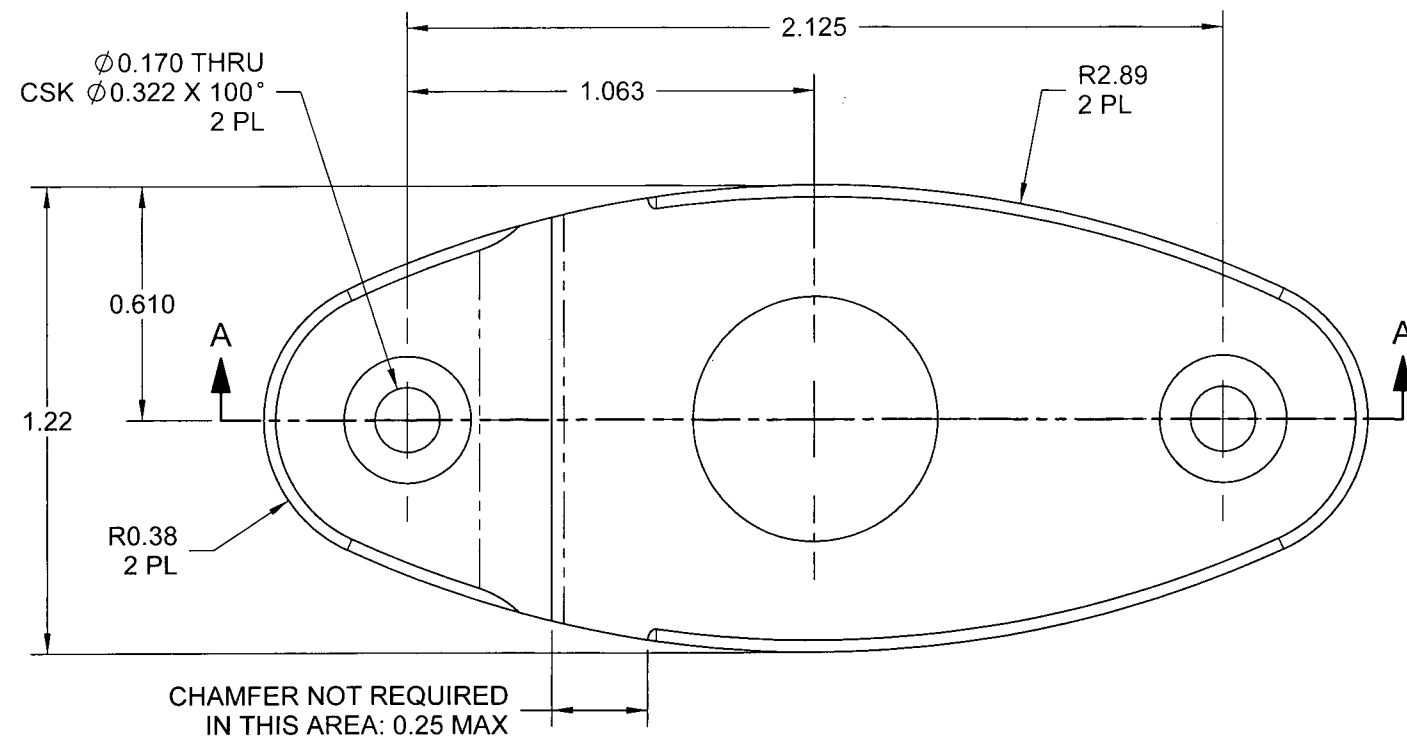
PRELIMINARY ISSUE

509.01.14 PER
ECN 09-502P

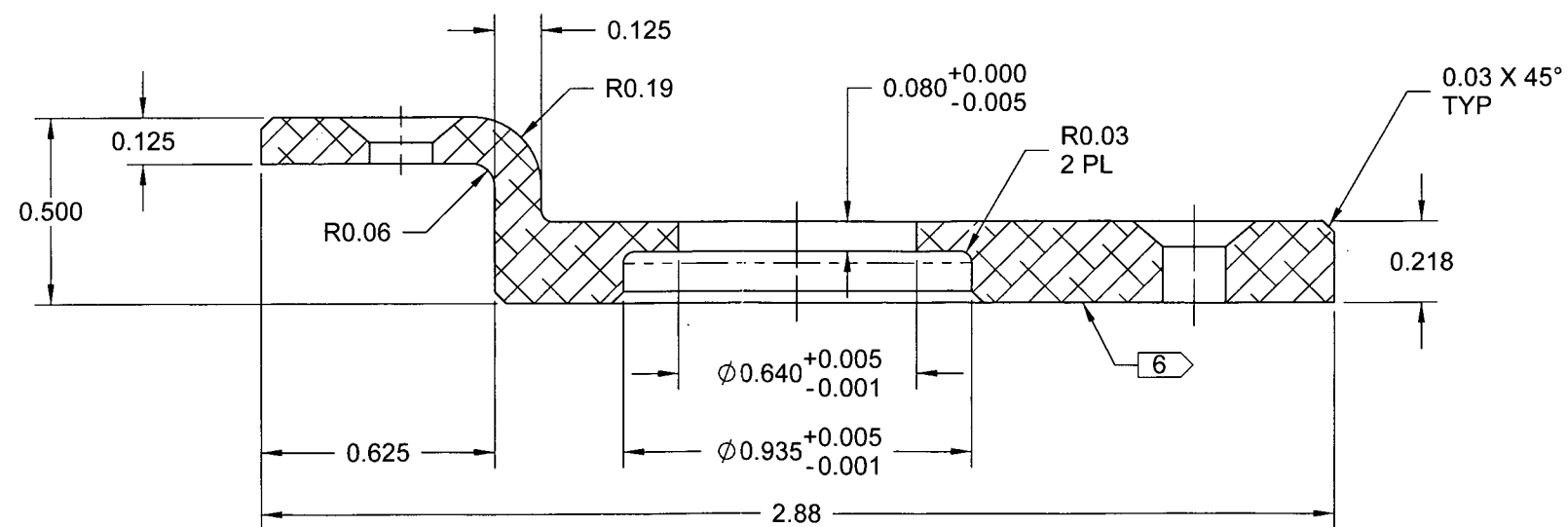
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3704-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.04 lbs

A	NEW ISSUE		MB	08.02.05
REV.	DESCRIPTION		BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED		DRAWING NO.	REV. A	
MFG. APPR.		D3704	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		ESCUTCHEON	NTS	
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D3704-1 ESCUTCHEON

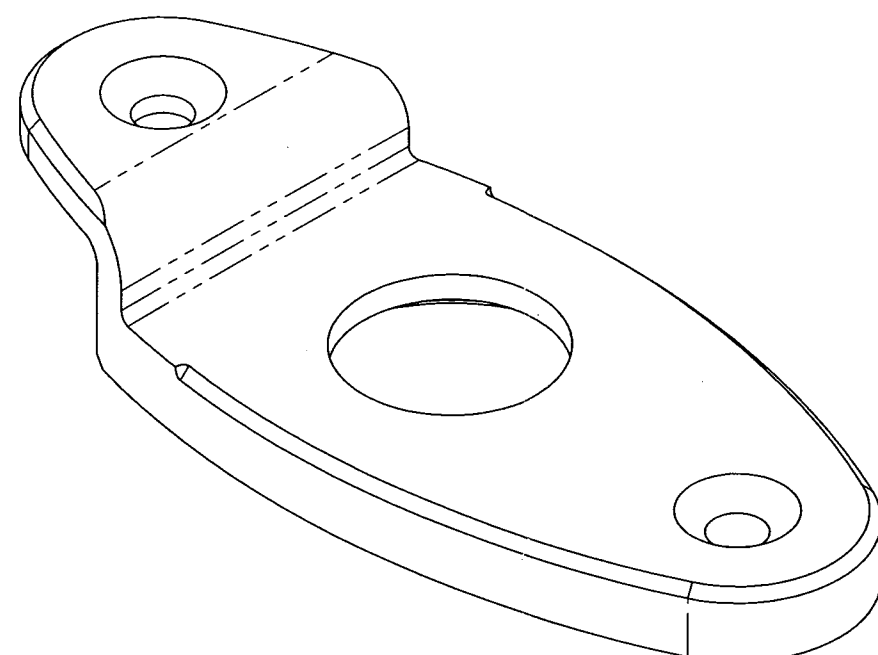


SECTION A-A

44761
PRELIMINARY ISSUE

209.01.14
PER ECN#04.502P

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3704	SHEET 2 OF 2
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D3704-1 ESCUTCHEON

44761

SUPERCEDED BY
09/04/14

RELEASED
09/04/09

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
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(REF. DART SPEC. M6061T6B)
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DESIGN			
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MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.02.05		
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44761

RELEASED
09/04/09

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DRAWN		
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